



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80260

February 15-12 3:34:33 PM

\*80260\*

Page 2

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

\*140\*

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad )

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch ( 65 deg C )

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

Alum. Rod # M120854

Da 12/03/16

10

φ

2

φ

12.04.27

Work Order ID 80260

\*80260\*

February-15-12 3:34:33 PM

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

160

QC9- Inspect visual per QS1004- Fusion Welds

0.00

\*160\*

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QS1005 4.1

0.00

\*170\*

HandFinish

Memo

0.00

Hand Finishing

5/26/12

10	12	03	19
72			
042			

2 0 3E12/04/30

27612-51



# Work Order ID 80260

\*80260\*

Page 4

February-15-12 3:34:33 PM

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Memo

0.00

Quality Control

2x

12/05/01

190

Small Fab

0.00

\*190\*

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

2x

12/05/01

200

QC5- Inspect part completeness to step on W/O

0.00

\*200\*

QC

Memo

0.00

Quality Control

2x

12/05/01

# Work Order ID 80260

\*80260\*

Page 5

February-15-12 3:34:33 PM

Item ID: D3560-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: WA

0.00

\*210\*

STEP CELL

2

A2  
12.05.01

Packaging

Memo

0.00

Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

220

QC21- Final Inspection - Work Order Release

0.00


\*220\*

QC

Memo

0.00

Quality Control

12/5/11 

mf  
12-05-01

# Picklist Print

February-15-12 3:34:36 PM

Page 1

Work Order ID: 80260

\*80260\*

Parent Item: D3560-042

\*D3560-042\*

Parent Item Name: Arm Weldment

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A New Issue 07.05.24 EC  
 IPP rev B ECN 987 07.10.09 EC verified by: DD  
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

70.0000

1

10

\*\*

\*D2808\*

Bushing

### Location

### Loc Qty

### Loc Code

GA

70

32896

2

76188

3

78950

24

79688

41

140

f

51.2274

1.395

14.68421

\*\*

M6061T6B0.500X05.00

Purchased

No

0

\*M6061T6B0 500X05 000\*

6061-T6 Bar .500 x 5.00

### Location

### Loc Qty

### Loc Code

MAT001

21.834

112154

6.935

117933

2.123

119346

12.776

MAT004

29.3934

120243

24

120421

5.3934

14.7

12/03/09

# Picklist Print

February-15-12 3:34:36 PM

Work Order ID: 80260

Parent Item: D3560-042

Parent Item Name: Arm Weldment

\*80260\*

\*D3560-042\*

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

D3592-1

Manufactured No

190

Each

27.0000

1

10

\*\*

12.04.27

\*D3592-1\*

Plate

Location

Loc Qty

Loc Code

WA

380379

4

78934

4

WA002

23

47015

2

78934

21

2





RELEASED  
D.R.N.



D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D3560-2 ARM

D3592-1 PLATE

0-041 ARM WELDMENT

D3560-042 ARM WELDMENT



D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

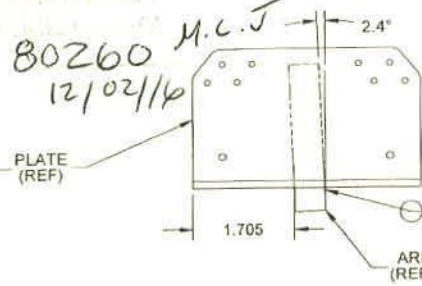
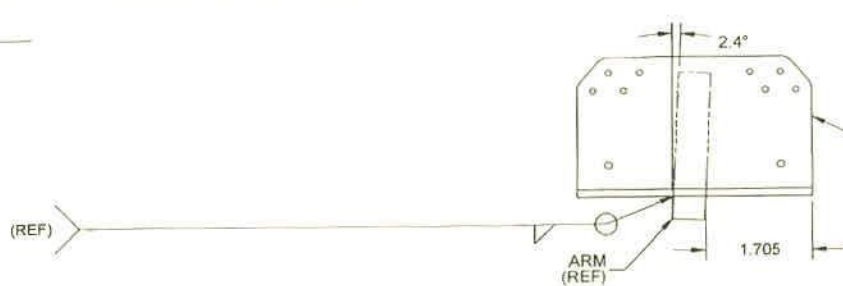
D2808 SPACER,  
PRESS FIT AFTER  
ALODINE

D3592-1 PLATE

D3560-4 ARM

60-043 ARM WELDMENT

D3560-044 ARM WELDMENT



DETAIL B  
SCALE 1 : 2

# PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

1 COAT PER DAY  
8 UNLESS OTHERWISE NOTED  
0.015 MAX

QSI 005 4.1  
WISE NOTED

DESIGN	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG. APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

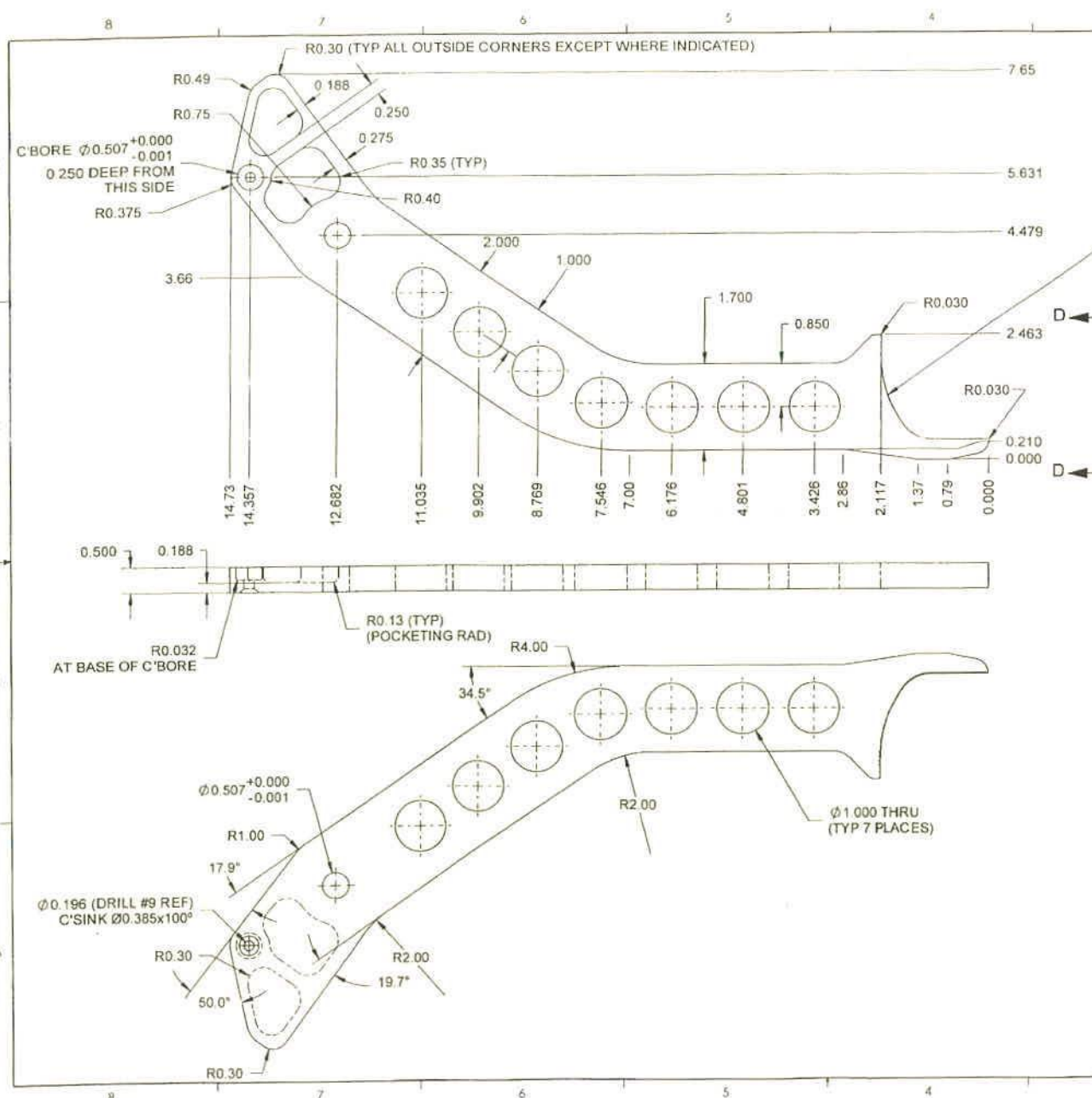
DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D  
D3560 SHEET 1 OF 5  
TITLE SCALE  
ARM WELDMENT 1:4

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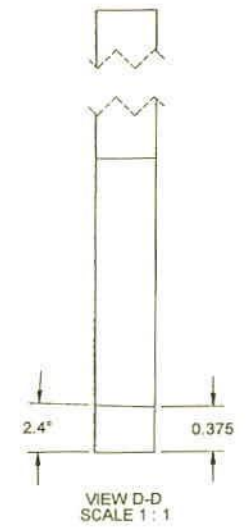
80260



PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4°,  
SEE VIEW D-D

### D3560-2 ARM

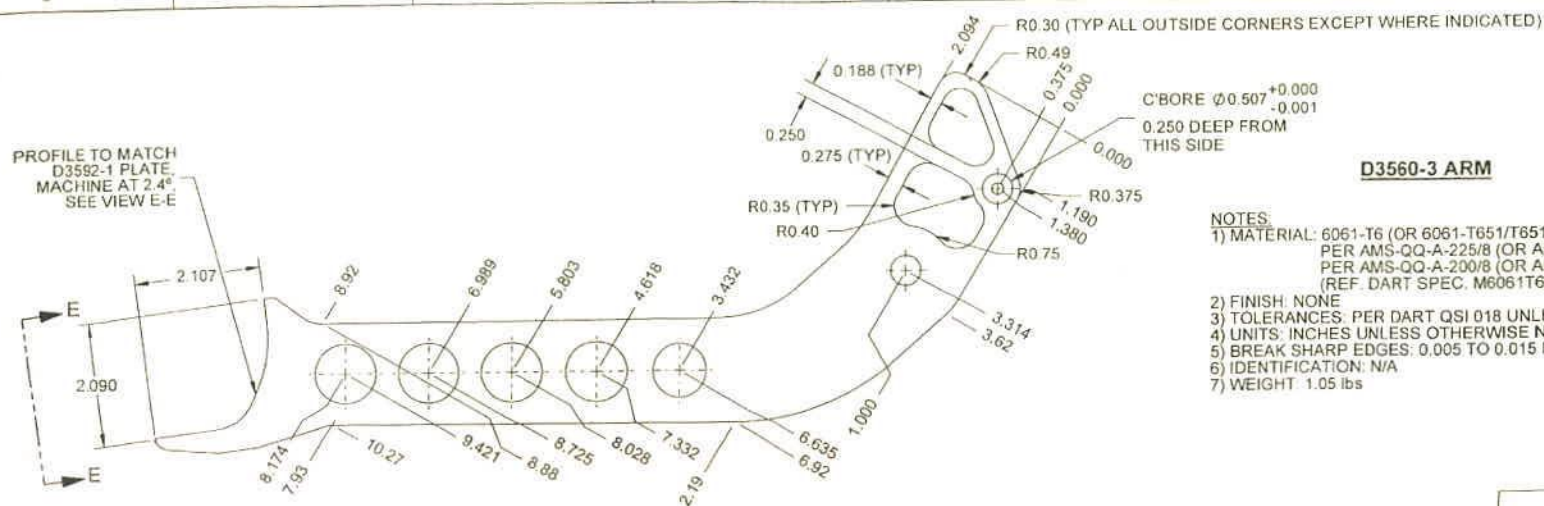
- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



DESIGN	JP	<b>DART AEROSPACE LTD</b>	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3560	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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80260

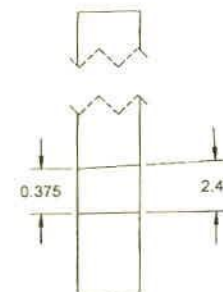
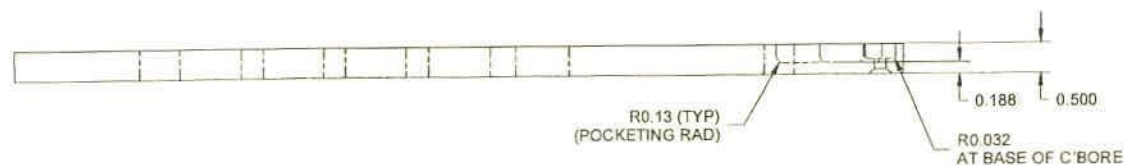
PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



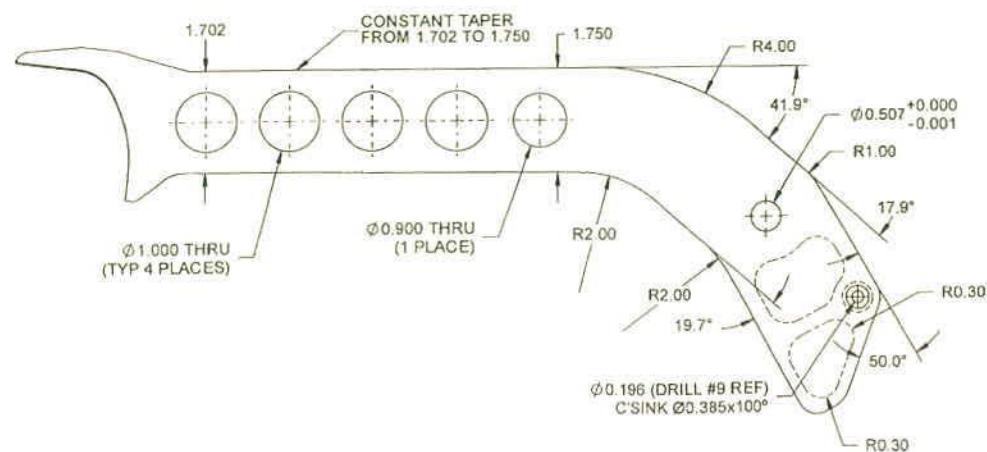
### D3560-3 ARM

#### NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW E-E  
SCALE 1:1



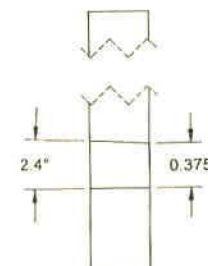
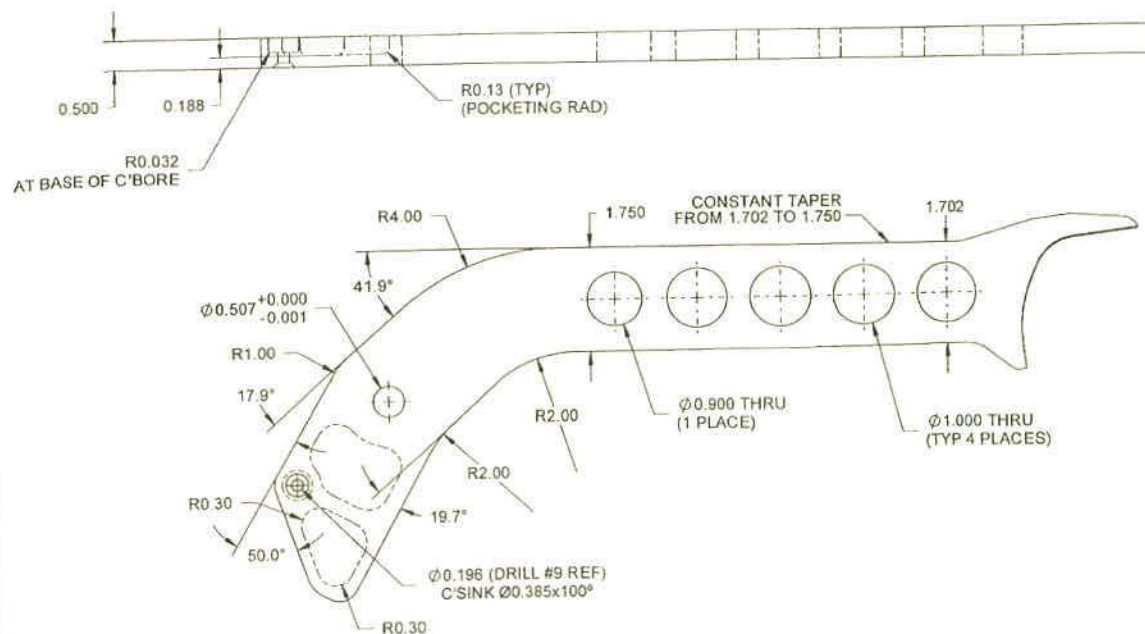
DESIGN	47	DART AEROSPACE LTD	
DRAWN	4C	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. D
MFG. APPR.	47	D3560	SHEET 4 OF 5
APPROVED	47	TITLE	SCALE
DE APPR.	47	ARM WELDMENT	1:2
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Technical drawing of a mechanical part, likely a bracket or arm, showing dimensions and tolerances. The part has a complex, curved profile with multiple holes and a central slot. Dimensions are given in inches, with some values in parentheses indicating typical values. A note specifies "C-BORE Ø0.507 +0.000 -0.001 0.250 DEEP FROM THIS SIDE". A section line F-F is shown on the right side, with a note "PROFILE TO MATCH D3592-1 PLATE. MACHINE AT 2.4°. SEE VIEW F-F". A list of notes is provided on the right: 1) MAT, 2) FINI, 3) TOLI, 4) UN.

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F  
SCALE 1 : 1

FILE  
107.12.18 MP

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. 0
CHECKED		D3560	SHEET 5 OF 5
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APPROVED		ARM WELDMENT	1:2
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DATE	07.11.16		